

Work Order ID 54954



Page 1

January 5, 2010 10:44:01 AM

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 05/01/2010 Start Qty: 1.00



List Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-1-05* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

8/10/02/01

HJ for MF 10/01/30

54954

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

10-Grind welds flush as per Dwg D2750

M 10/1/13

M112860

BE 10/6/14

M 10/1/14

W/O:		WORK ORDER CHANGES					
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Page 3

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Date:

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QC:

Date:

SPC (Y/N):

Date:

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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

12- Scribe batch# inside per dwg D2750

M 10/1/13

120

QC10- inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

27 8/10/14

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

27 8/10/14

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

1 M 10/1/14

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10-1-15

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 5

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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M12395

exp. date: 12/8/12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: M112860

8C 10/6/19

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places perside) as per
dwg D2750

H 10/1/15

M 10/1/15

AWM 10-1-19

W/O:		WORK ORDER CHANGES					
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January 5, 2010 10:44:02 AM



Page 6

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Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

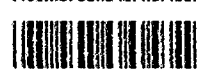
Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- At section AJ-AJ drill out x-bolt spacer to 0.404"

> SC 10/6/19

12-Deburr holes

170

QC10- Inspect visual per QS1004- ground welds

0.00

QC

Memo

0.00

=> S. 10.6.180



Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

=> S. 10.6.180



Quality Control

W/O:		WORK ORDER CHANGES					
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Page 7

January 5, 2010 10:44:02 AM

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

=> M

10-01-21

(X)

0

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

=> M

10-01-21

(X)

Powder Coating

START TIME: 11:30AM
OVEN TEMPERATURE: 320°C
FINISH TIME: 12:00PM

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

GR 10-01-26

0

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January 5, 2010 10:44:02 AM



Page 8

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

BR 10-01-26 ①.

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: _____

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 112345

EXP DATE: 10/09

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 101223

5-Coat all exposed fasteners with "LPS Procyon" batch: 104251

BR 10-01-26 ①.

W/O:		WORK ORDER CHANGES					
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January 5, 2010 10:44:02 AM



Page 9

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/10/10/27



QC

Memo

0.00

(X6)

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

10-1-29

SP

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

⇒ 8/10/10/1



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
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Page 10

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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

Rev A

10-2-8

10/02/09
ME 10-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:06 AM

Page 1

Work Order ID: 54954

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	-----------------	----------------	--------------------------	---------------	----------------	--------

D2594-3		Manufactured	No			230	Each	362.0000	8.0000			
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O-Ring, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 27

51613 27

Main Warehouse

ST 335

52562 ✓ 335

D2744		Manufactured	No			110	Each	60.0000	1.0000			
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Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 60

44892 1

47488 23

51922 36

8. BL 10-01-26.

1 10/1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	16.0000	1.0000			

Extrusion Bent

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	5	
50675	5	
Main Warehouse		
ST	11	
43495	1	
47133	1	
52346	9	

D2743

Manufactured No



Crossbolt Spacer

160 Each 299.0000 8.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	94	
50281	50	
51913	44	
Main Warehouse		
ST	205	
44891	2	
45555	17	
48275	1	
52310	185	

1 H 10/1/13

2 BE 10/01/18

6 BE 10/01/18

W/O:		WORK ORDER CHANGES					
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Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739		Manufactured	No			160	Each	5.0000	1.0000			

350 I Beam

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
47124	1	
53900	4	

D3490-3

Manufactured No

160 Each 37.0000 4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	37	
45560	1	
48276	31	
51930	5	

Q/B

41011/15

4 SE 10/21/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Component Item ID/ Item Name	Replacement Item	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	84.0000	4.0000			

Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	84	
45338	2	
47657	22	
48277	20	
51932	40	

4 26 10/21/18

ALS4-1032-225 Purchased No

220 Each 6,691.000 38.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6691	
107441	16	
110768 ✓	6675	

38. PR 10-01-26.

D3492-041 Manufactured No

230 Each 76.0000 8.0000



Plug Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	76	
51584 ✓	76	

8 PR 10-01-26.

January 5, 2010 10:44:06 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:06 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3		Manufactured	No			230	Each	16.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
51592 ✓	12	
51903	4	

1 B/L 10-01-26

AN8C35A

Purchased

No

230

Each

137.0000

1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	137	
102180	1	
106896	1	
110105	48	
110847 ✓	87	

1 B/L 10-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:06 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH.

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1		Manufactured	No			230	Each	19.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	19	
40551	1	
51597 ✓	16	
51906	2	

1 BR 10-01-26.

D3488-041

Manufactured No

230

Each

14.0000

1.0000



Blade Fitting Assembly, LH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
47348 ✓	14	

1 BR 10-01-26.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:06 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3		Manufactured	No			230	Each	21.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	18	
51598 ✓	6	
51907	12	
Main Warehouse		
ST	3	
46531	2	
47440	1	

1 PR 10-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:06 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replace Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	-----------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN6C44A Purchased

No

230

Each

148.0000

4.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

146

110105

4

110155

14

110665

1

111605

50

111649

50

112720

9

113121

18

4 BR 10-01-26 -

MS21083C8

Purchased

No

230

Each

53.0000

1.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

110584

5

111424

2

112492

6

113149

40

1 BR 10-01-26 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:06 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25		Manufactured	No			230	Each	40.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP10	35	
51607 ✓	9	
54479	26	
Main Warehouse		
ST	5	
45569	1	
47011	2	
47526	2	

1 BK 10-01-26.

D3631-1

Manufactured No

230 Each 442.0000 8.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	442	
52693 ✓	142	
54388	300	

8 BK 10-01-26.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:06 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component/Item Name	ID/Item ID	Replacement Item ID	Mfg/Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	State Issued	Status
D3791-1			Manufactured	No			230	Each	11.0000	1.0000			

Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

51610 ✓

7

Main Warehouse

ST

4

51909

4

AN960C10L

Purchased

No

230

Each

416.0000

38.0000



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

316

112116

156

112612

160

NAS1149C0332R

113288.

38. BL 10-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

January 5, 2010 10:44:06 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2745		Manufactured	No			230	Each	346.0000	8.0000			
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Bushing

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	59	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
43754	2	
44893	33	
45556	1	
Main Warehouse		
ST46	287	
51537 ✓	70	
51910	36	
52311	181	

8 BX 10-a-26

January 5, 2010 10:44:06 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:07 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A		Purchased	No			230	Each	609.0000	34.0000			



Bolt

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST 113644	609	
111424	8	
111707	69	
112314	1	
113121	231	
113149	300	

34- BR 10-01-20.

D3537-1

Manufactured No

230 Each 141.0000 3.0000



Wearpad

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	139	
51678 ✓	34	
51679	105	

3 BR 10-01-20.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:07 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L 		Purchased	No			230	Each	240.0000	1.0000			
WASHER												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	240	
104093	2	
107520	4	
110139	29	
110584	100	
111424 ✓	105	

D3492-043

Manufactured No

230

Each

143.0000

8.0000



Plug Assembly

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	123	
54682 ✓	123	
Main Warehouse		
ST	20	
52309	20	

1 PR 10-01-26.

8 PR 10-01-26.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 14

January 5, 2010 10:44:07 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A 		Purchased	No			230	Each	828.0000	4.0000			
BOLT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

828

111982 ✓

828

NAS1611-013

Purchased

No

230

Each

74.0000

8.0000



O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

74

106513

11

111424

20

111758

43

4 PR 10-01-26

8. PR 10-01-26

January 5, 2010 10:44:07 AM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:07 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25		Manufactured	No			230	Each	15.0000	1.0000			

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

51927 ✓

7

Main Warehouse

ST

8

52589

8

D3794-1

Manufactured

No

230

Each

15.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51928 ✓

12

Main Warehouse

ST

3

46530

1

47212

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:07 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6 		Purchased	No			230	Each	1,000.000	4.0000			

NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1000	
111424	8	
112314 ✓	992	

D3493-1

Manufactured No

260	Each	55.0000	2.0000
-----	------	---------	--------



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	55	
44902	2	
47710	53	

4 BR 10-01-26
lu

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:07 AM

Work Order ID: 54954



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Qty Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 NUT		Purchased	No			260	Each	53.0000	2.0000			

10-1-29

SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	53	
110584	5	
111424	2	
112492	6	
113149	40	

AN8C21A

Purchased

No

260

Each

148.0000

2.0000

BOLT

10-1-29

SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	148	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
112720	38	
113558	50	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:07 AM

Work Order ID: 54954

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L WASHER		Purchased	No			260	Each	240.0000	2.0000			

10-1-29 sf

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	240	
104093	2	
107520	4	
110139	29	
110584	100	
111424	105	

2

D3672-1

Manufactured No



Phenolic Washer

230 Each 1,744.000 4.0000

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1244	
39275	19	
42329	5	
47628✓	220	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

H. BR 10-01-26.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:07 AM

Work Order ID: 54954

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC


Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741		Manufactured	No			260	Each	45.0000	1.0000		10-1-29	SP
												
Blade, 350 Skidtube												

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

45

45320


1

47113

4

51931

40

D3532-1		Manufactured	No			260	Each	80.0000	2.0000		10-1-29	SP
												
Spacer												

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST


80

44904

2

52321

78

D3672-13		Purchased	No			260	Each	948.0000	2.0000		10-1-29	SP
												
Phenolic Washer												

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

948

54363

948

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BLADE HING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3489-1	SPACER
4	4			D3489-3	SPACER
		4	4	D3489-5	SPACER
8	8	8	8	D3489-041	PLUG ASSEMBLY
8	8			D3489-043	PLUG ASSEMBLY
		8	8	D3489-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3531-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN305A	BOLT
4	4	4	4	AN305A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN9C35A	BOLT
38	38	38	38	AN950C10L	WASHER
1	1	1	1	AN950C16L	WASHER
4	4	4	4	WS21043-E	NUT
1	1	1	1	WS21043CE	NUT
4	4	4	4	NAS1515H3L	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34954
BA 10-1-05

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08-07-16

GENERAL NOTES:

MATERIAL: MAKE D2750-1/2/3/4 FROM D2500-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041-042-043-044 = 265.1 LBS

WELD PER DART QSI 004

INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 1" SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS

FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 35 KSI

MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI

1) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF

POWDER COATING WITH MEK DEGREASER

2) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

3) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1). D3791-1/3 REPLACES D3535-13/35 (ZN C8-1). D3794-1/3 REPLACES D3536-13/35 (ZN C8-1). ADD D3791-1 (ZN C8-1). WEARSHOE HOLES UNDER FINDAIST SADDLE REMOVED (3 PL). WEARSHOE HARDWARE QTY UPDATED (ZN C8-1). D3488-041/042 HARDWARE UPDATED (ZN C1-6, 8, 10, 11). ADD NOTE 12 AND 13 (ZN A6-1). REASON: REF. NCR 08-043	PH	06.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES. ADD RUBBER GASKETS. CHANGE INSERTS: ADD D3631-1. REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H8L, REMOVE D2741, QTY (2) AN950C816, REMOVE QTY (2) WS2108306	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS. INCORPORATE DEO 9123/5157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2746	CP	06.11.12
B	CHANGE MS24694-5293 TO AN8-15A	CP	06.03.01
A	NEW ISSUE	DS	06.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED	REV	DRAWING NO.	REV. F
MFG. APPR.	REV	D2750	SHEET 1 OF 1
APPROVED	REV	TITLE	SCALE
DE APPR.	REV	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

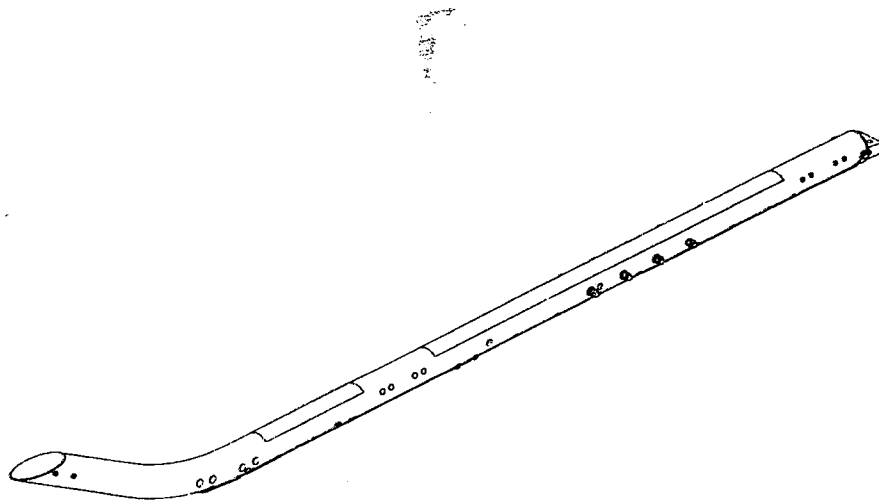
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

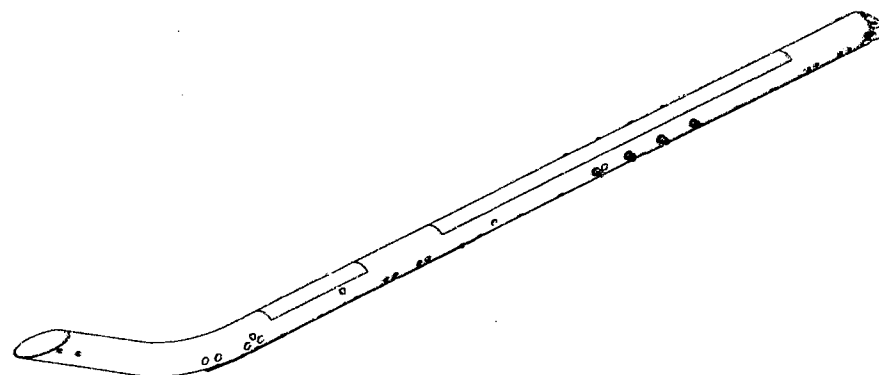
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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1989-07-22

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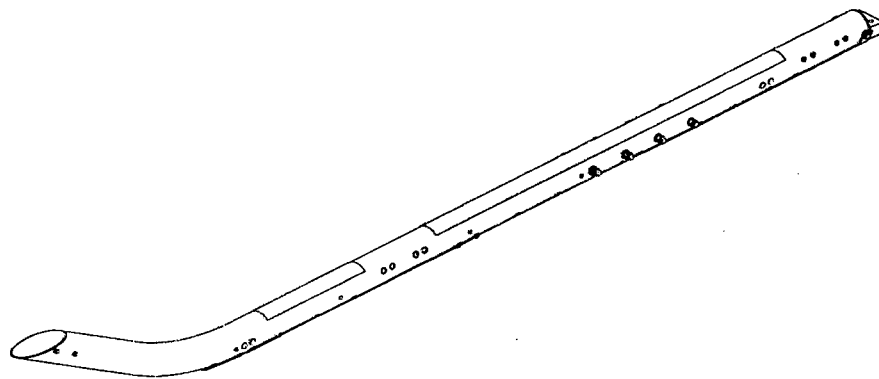
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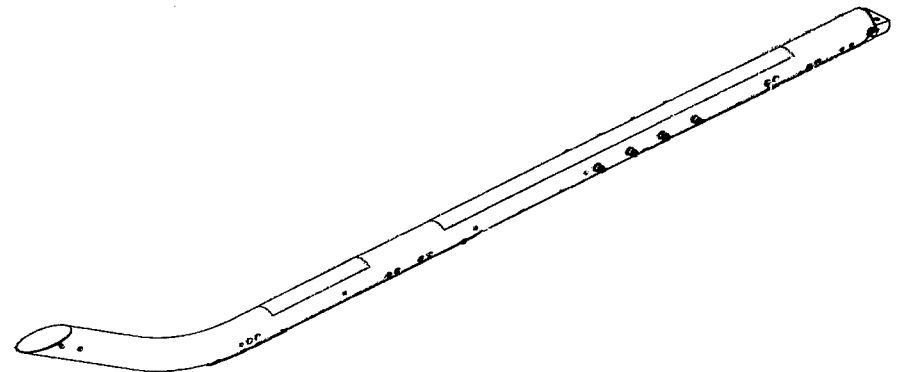
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NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-09-10-100

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CHECKED	MA	DRAWING NO. D2750	REV. F
MFG. APPR.	MA	SHEET 3 OF 11	
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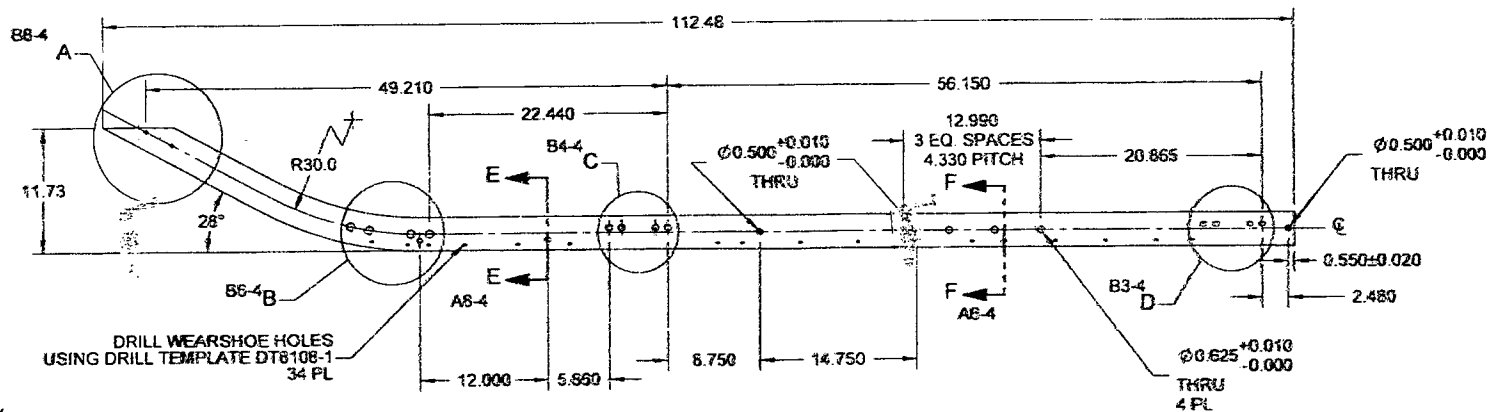
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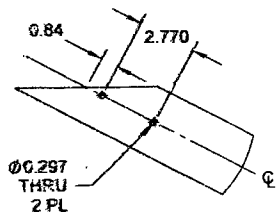
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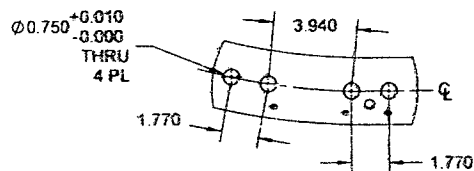
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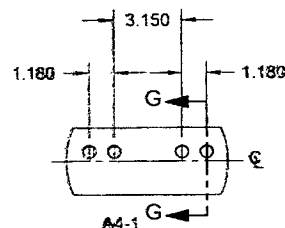
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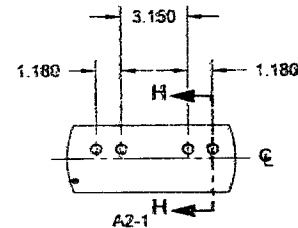
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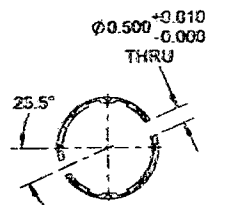
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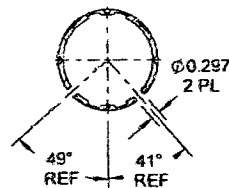
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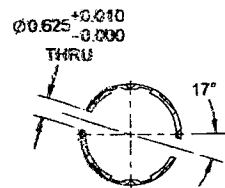
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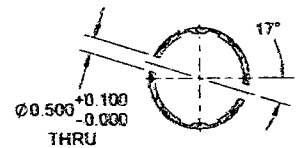
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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MFG. APPR.	1/8	D2750	SHEET 4 OF 11
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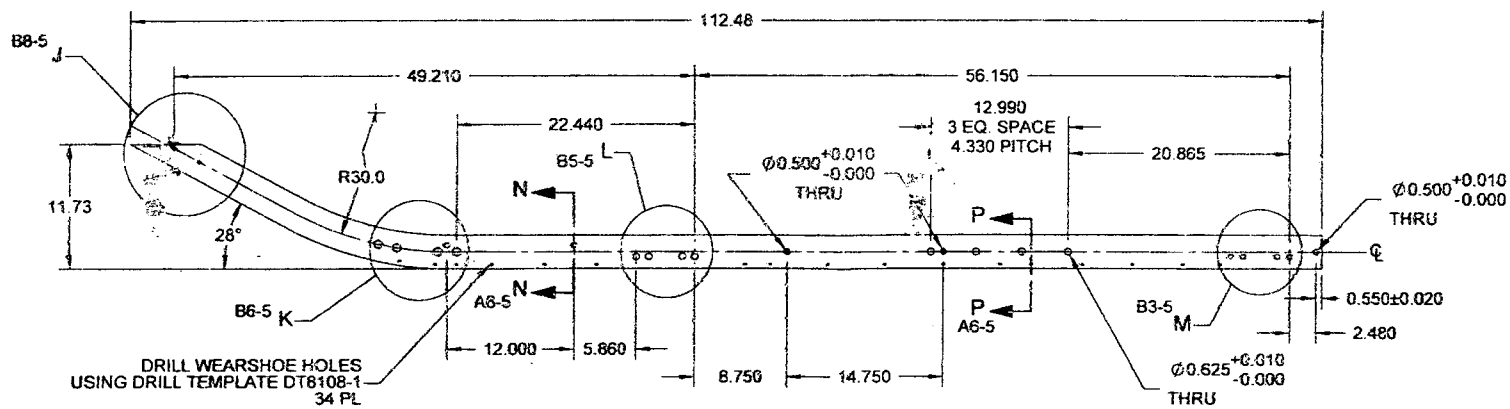
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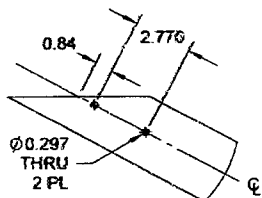
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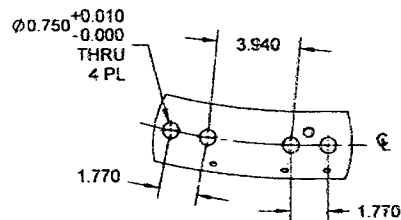
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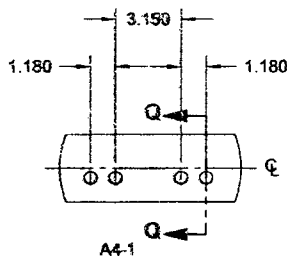
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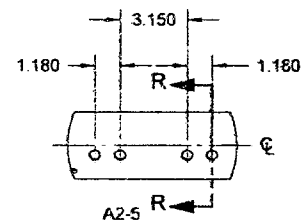
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SCALE 2X



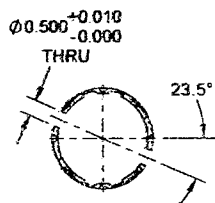
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SCALE 2X



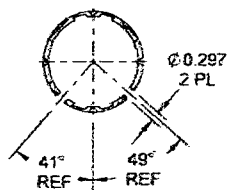
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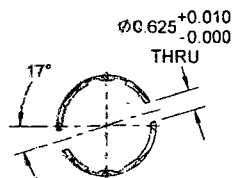
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SCALE 2X



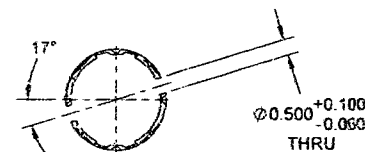
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY	SHEET 5 OF 11
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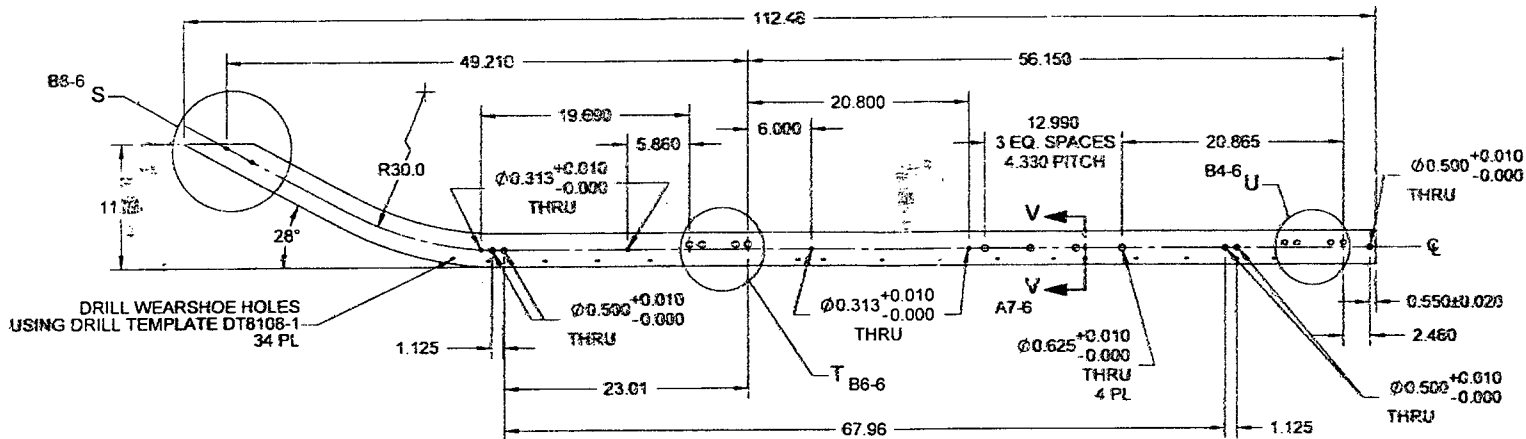
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

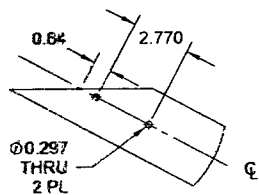
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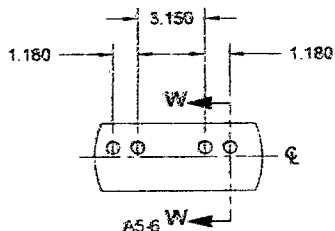
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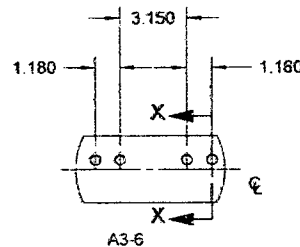
D2750-3 LH SKIDTUBE



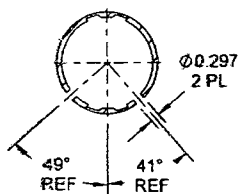
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SCALE 2X



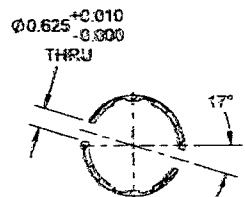
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C5-6
SCALE 2X



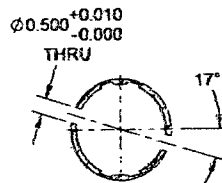
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

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w/lo 54954

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MFG APPR.		SHEET 6 OF 11	
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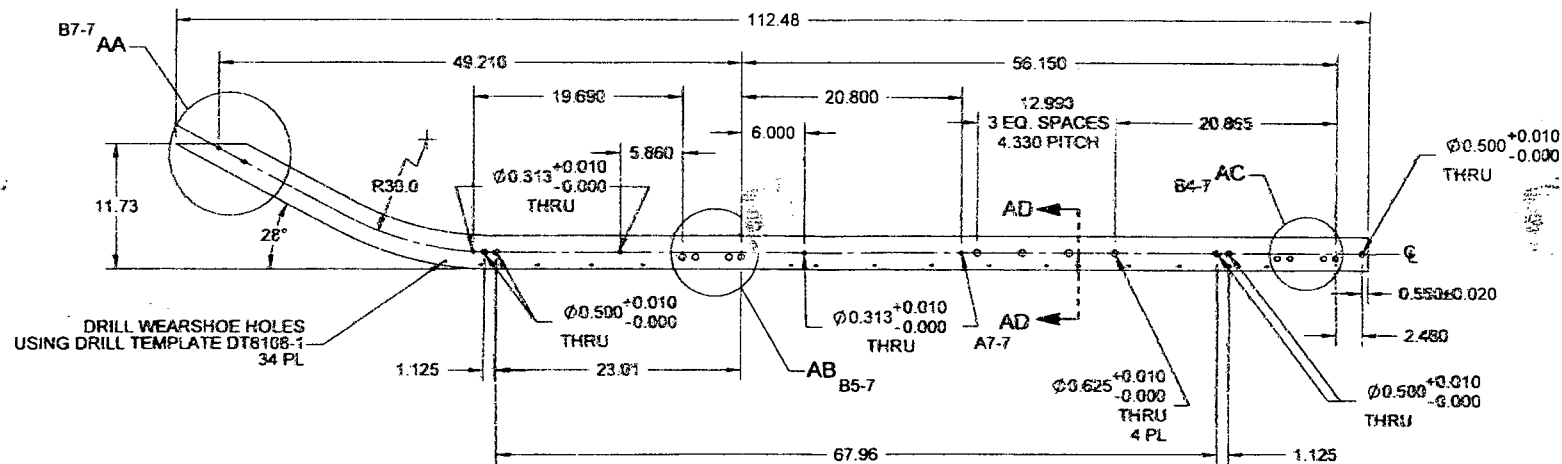
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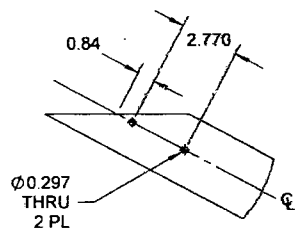
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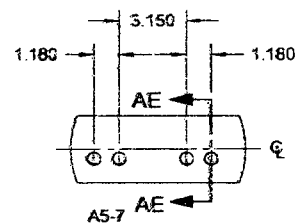
NOTE: Date & initial all entries



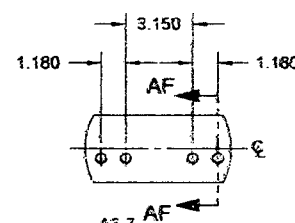
D2750-4 RH SKIDTUBE



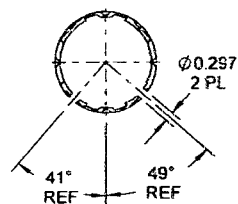
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SCALE 2X



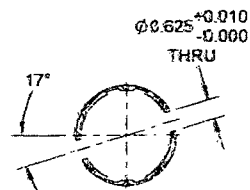
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SCALE 2X



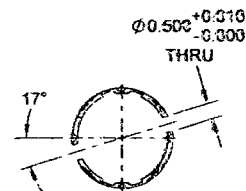
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED
06-92-10

DESIGN	W/10 54954	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	MTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

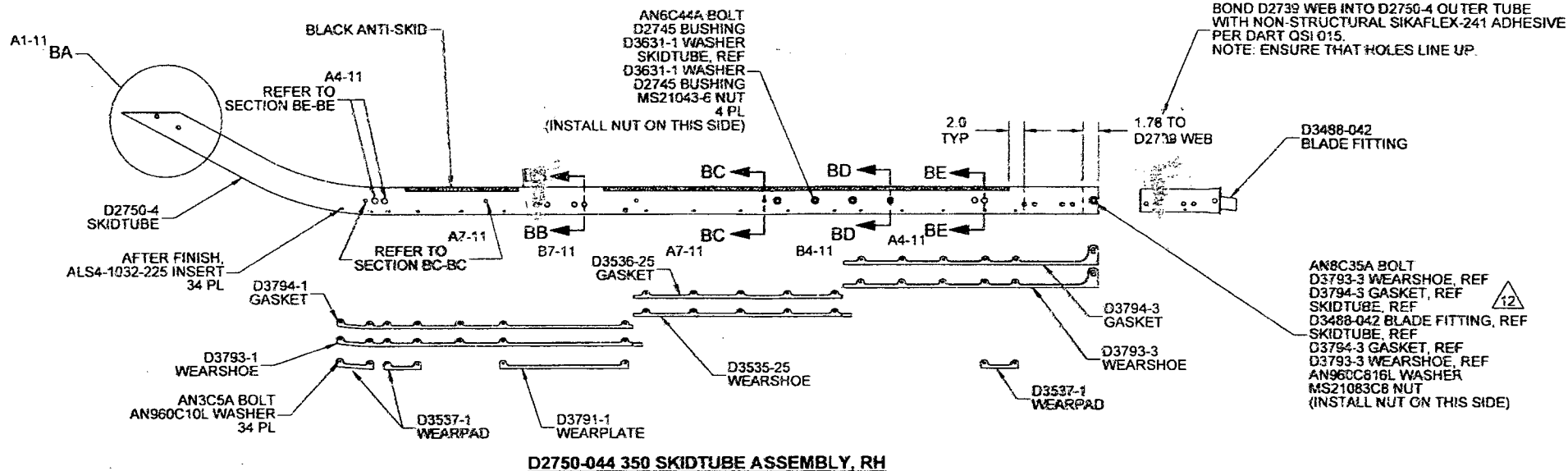
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

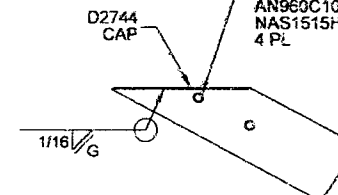
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



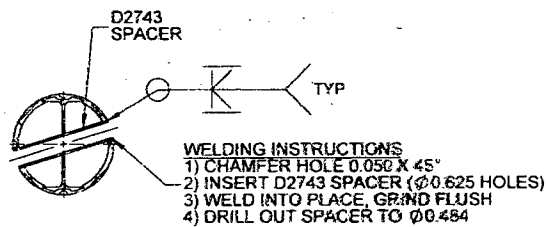
RELEASED

AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C5A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

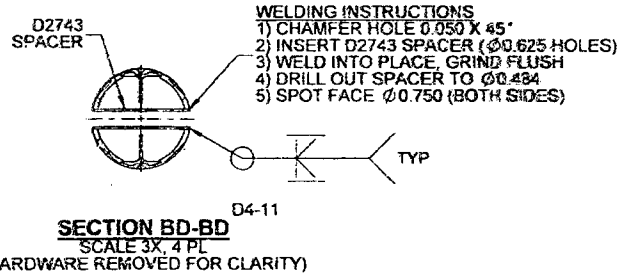


DETAIL BA
SCALE 2X

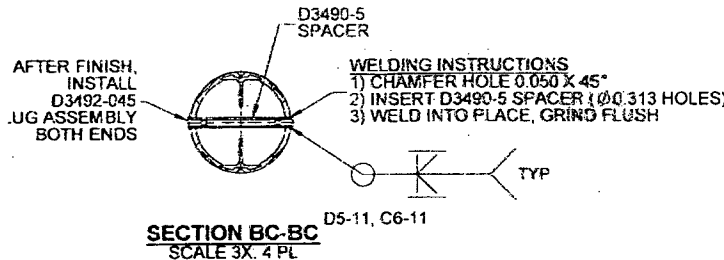
D8-11



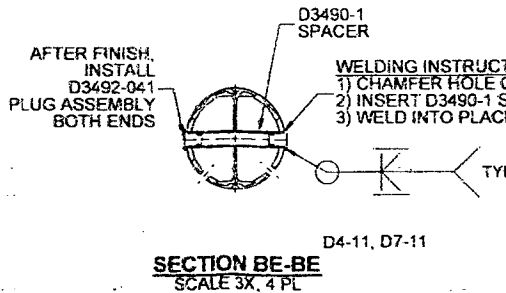
D6-11



D4-11



D5-11, C6-11



D4-11, D7-11

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DRAWN	W/0 54954	PORT HADLOCK, WA	
CHECKED	W/0 54954	DRAWING NO.	REV. F
MFG. APPR.	W/0 54954	D2750	SHEET 11 OF 11
APPROVED	W/0 54954	TITLE	SCALE
DE APPR.	W/0 54954	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 222

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54986
Part number: D350-636-012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10.01.11

Welder Barclay Elliott Date of Test Coupon 10-01-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld